

slp 10/03

PRELIMINARY ISSUE

Work Order ID 67152



Page 1

Wednesday, March 09, 2011 11:31:18 AM

Item ID:	D4327-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Angle					
Start Date:	3/9/2011	Start Qty: 1.00		Cust Item ID:		
Required Date:	3/10/2011	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4327	PA1

100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
2021.046	1-Cut as per Dwg								
	Dwg Rev: PA1								
	Prog Rev: PA1								
	2-Deburr if necessary								(1)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

1311-3-9

1311-3-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67152

Wednesday, March 09, 2011 11:31:18 AM



Page 2

Item ID: D4327-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Angle

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>Inspector 10 PA1</i> <i>Don or by</i> <i>Sutton/10</i>						
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
135 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

*1 11-8-10**11/3/10*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67152

Wednesday, March 09, 2011 11:31:18 AM

Page 3

Item ID: D4327-1

Accept

Revision ID: PRELIM

Item Name: Angle

Start Date: 3/9/2011 Start Qty: 1.00

Required Date: 3/10/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10

U 11.03.10

RD2320

POSITIVE RECALL

EFFECTIVE 11.03.10

AUTH

DATE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 11:31:15 AM

Work Order ID: 67152



Parent Item: D4327-1



Parent Item Name: Angle

Start Date: 3/9/2011

Required Date: 3/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	184.0595	0.234	0.246316			
2024-T3 .040 sheet													



B11-3-9

Location

Loc Qty

Loc Code

MAT

11.8

114415

11.8

MAT22

172.2595

110305

21.93

111786

7.66

112291

14.25

112331

52

113162

76.4195

110305

①

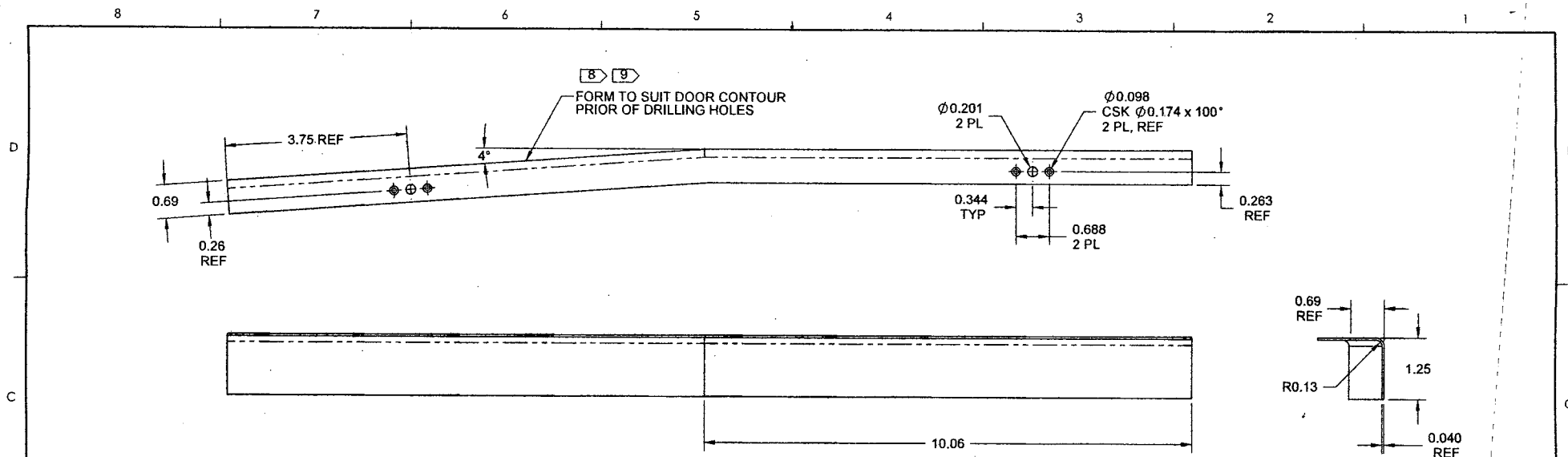
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

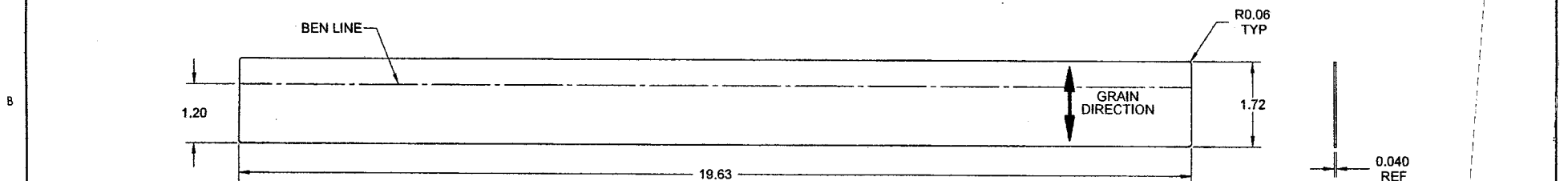
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D4327-1 ANGLE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)



D4327-1F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) FORM TO SUIT DOOR PROFILE
- 9) TRANSFER $\phi 0.201$ & $\phi 0.098$ FROM D4268-041 OR -043 OR -045 OR -047

4067152

PRELIMINARY ISSUE

10.11.22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.	<i>[Signature]</i>	D4327	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

